

We claim:

1 1. A method of making a fiber laminate comprising the
2 steps of:

3 (a) forming a nonwoven spunbond filament layer;

4 (b) prebonding said nonwoven spunbond filament layer to a
5 tensile strength of at least 50% of the tensile strength thereof
6 at maximum bonding to form a prebonded nonwoven spunbond filament
7 layer;

8 (c) applying at least one layer of hydrophilic fibers
9 onto said prebonded nonwoven spunbond filament layer; and

10 (d) hydrodynamically bonding a laminate formed by said
11 fibers together to form an absorbent cloth.

1 2. The method defined in claim 1 wherein the nonwoven
2 spunbond filament layer is prebonded in step (b) in a calender.

1 3. The method defined in claim 2 wherein the nonwoven
2 spunbond filament layer is prebonded in step (b) in a calender
3 having at least one heated embossing drum cylinder.

1 4. The method defined in claim 3 wherein the prebonding
2 is carried out in step (b) such that a maximum free filament
3 length between two bonding points of the nonwoven spunbond layer
4 is less than 15 mm.

1 5. The method defined in claim 4, further comprising the
2 step of additionally deforming said prebonded nonwoven spunbond
3 filament layer to increase the thickness thereof.

1 6. The method defined in claim 5, further comprising the
2 step of treating said prebonded nonwoven spunbond filament layer
3 with at least one wetting agent prior to application of said ,
4 fibers thereto.

1 7. The method defined in claim 6 wherein said wetting
2 agent is at least one tenside or surface active agent.

1 8. The method defined in claim 7 wherein the hydrophilic
2 fibers are applied by at least one carding machine or at least
3 one air-layering device onto the prebonded nonwoven spunbond
4 filament layer.

1 9. The method defined in claim 8, further comprising
2 the step of applying a second spunbonded nonwoven material onto
3 said laminate formed by said layers.

1 10. The method defined in claim 9 wherein the
2 hydrodynamic bonding of said layers into said laminate is
3 effected by a water-jet treatment thereof.

1 11. The method defined in claim 1 wherein the prebonding
2 is carried out in step (b) such that a maximum free filament
3 length between two bonding points of the nonwoven spunbond layer
4 is less than 15 mm.

1 12. The method defined in claim 1, further comprising
2 the step of additionally deforming said prebonded nonwoven
3 spunbond filament layer to increase the thickness thereof.

1 13. The method defined in claim 1, further comprising
2 the step of treating said prebonded nonwoven spunbond filament
3 layer with at least one wetting agent prior to application of
4 said fibers thereto.

1 14. The method defined in claim 13 wherein said wetting
2 agent is at least one tenside or surface active agent.

1 15. The method defined in claim 1 wherein the
2 hydrophilic fibers are applied by at least one carding machine or
3 at least one air-layering device onto the prebonded nonwoven
4 spunbond filament layer.

1 16. The method defined in claim 1, further comprising
2 the step of applying a second spunbonded nonwoven material onto
3 said laminate formed by said layers.

1 17. The method defined in claim 1 wherein the
2 hydrodynamic bonding of said layers into said laminate is
3 effected by a water-jet treatment thereof.